TABLE OF CONTENTS

1- scale print of MK II sten

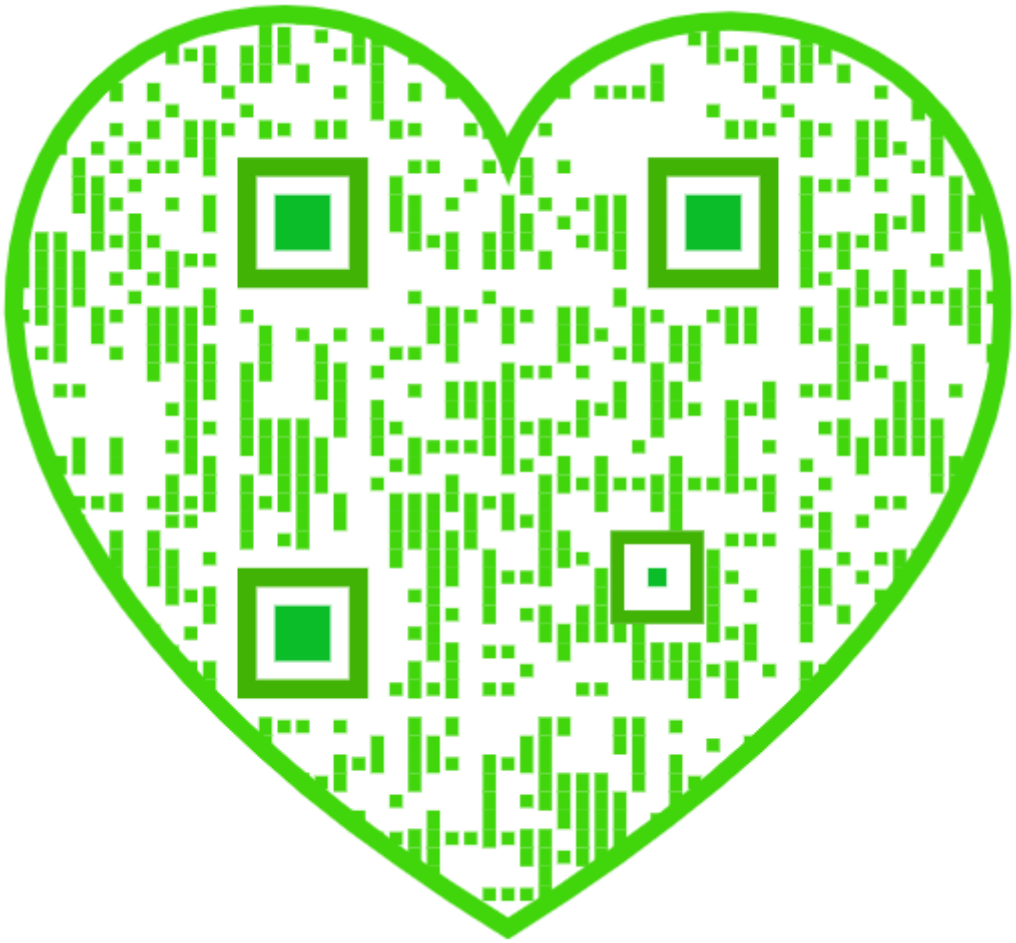
1- scale print of MP-40

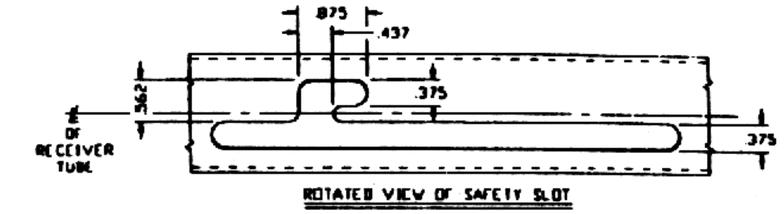
1- scale print of MK II sten compact

1- scale print of Yugoslav 56

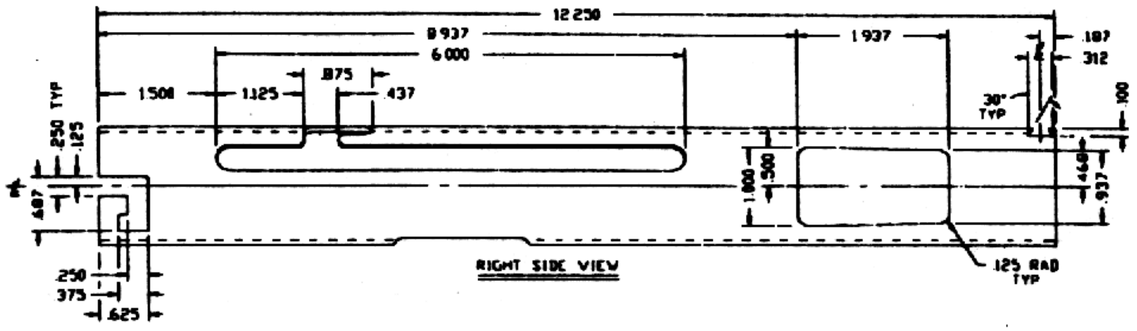
1- scale print of BMG 50
right and left sides

PARTS SUPPLIERS ON LAST PAGE

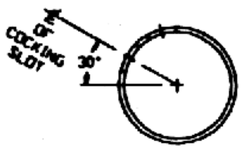


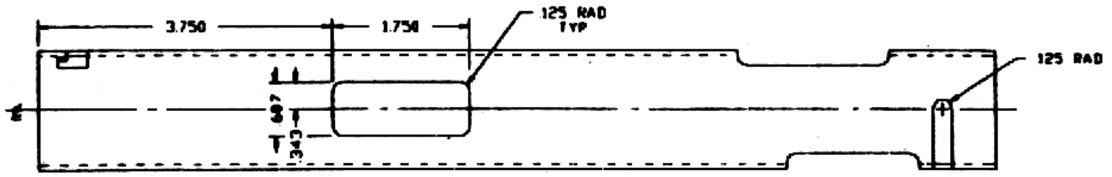


ROTATED VIEW OF SAFETY SLOT

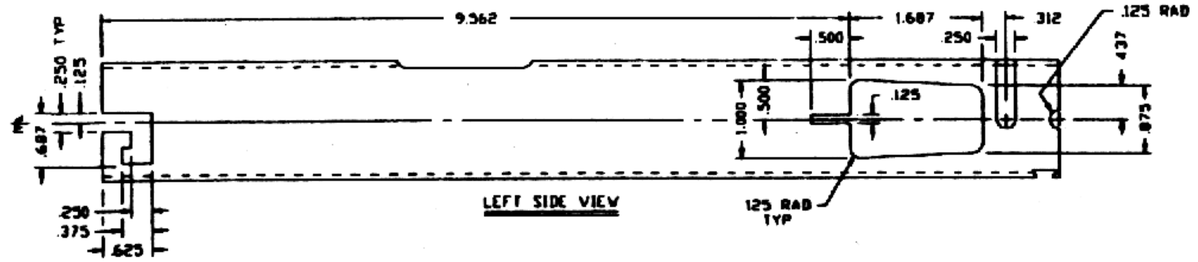


RIGHT SIDE VIEW

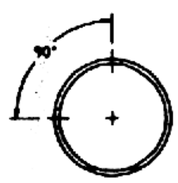




BOTTOM VIEW



LEFT SIDE VIEW

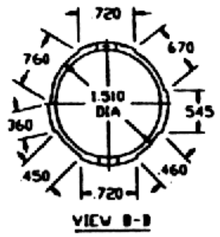


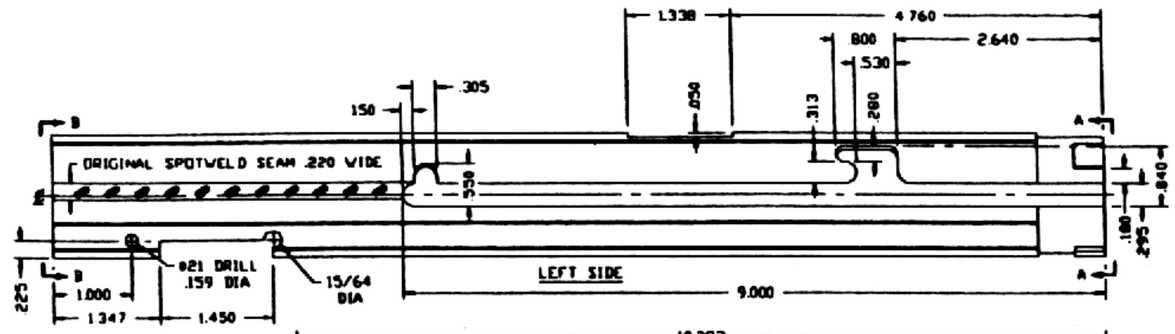
RESTRICTED MATERIAL

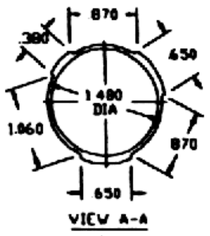
CONFIDENTIAL

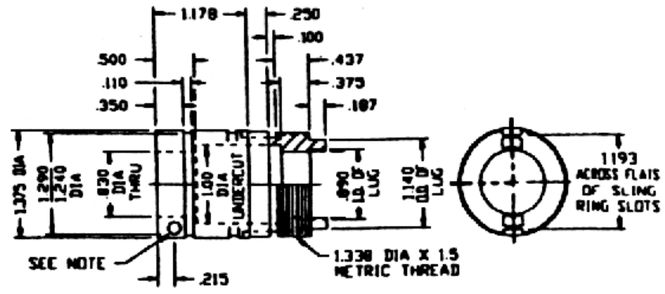
NOTES:
1. MATERIAL- MILD STEEL SEAMLESS . DRAWN OVER MANDREL 1.500 O.D. X 1.375 I.D. (.050-.062 WALL)
2. FINISH- PAINT BLACK

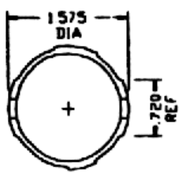
SCALE FULL	MATERIAL SEE NOTE 1	FSN	TOLERANCES
DRAWN	FINISH SEE NOTE 2	DATE	
TITLE STEN MK-II RECEIVER (STANDARD MODEL)		REV.	

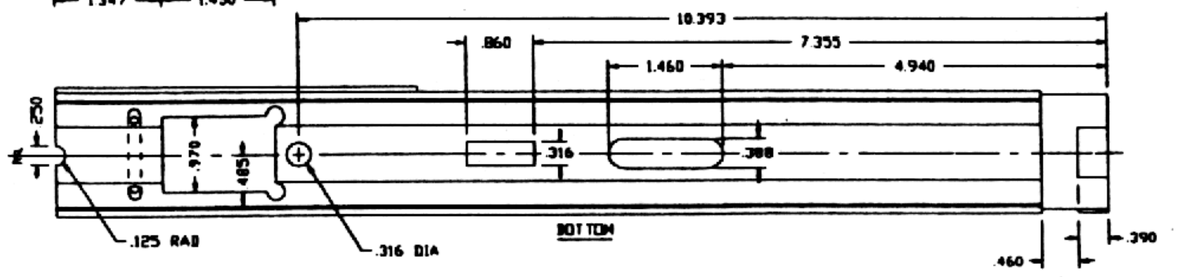


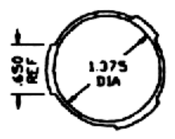


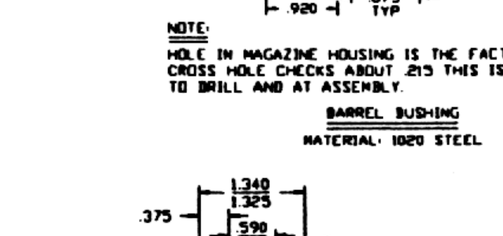








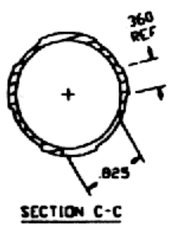


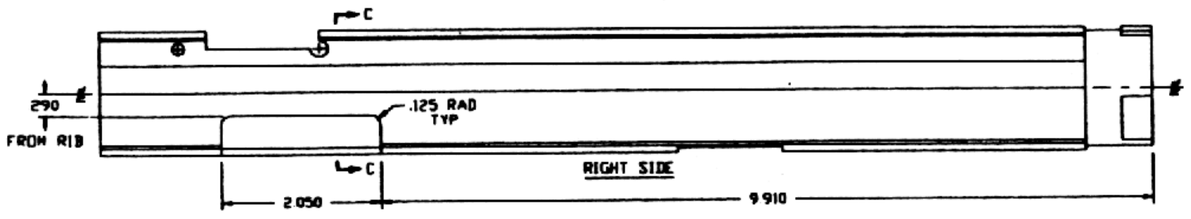


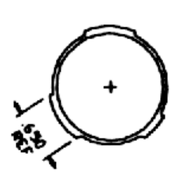
NOTE:
HOLE IN MAGAZINE HOUSING IS THE FACTOR WHEN ASSEMBLED CROSS HOLE CHECKS ABOUT .215 THIS IS THE LAST HOLE TO DRILL AND AT ASSEMBLY.

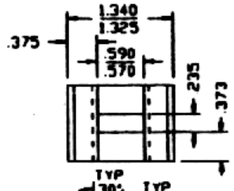
BARREL BUSHING

MATERIAL: 1020 STEEL



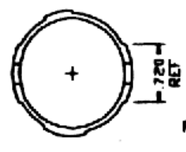


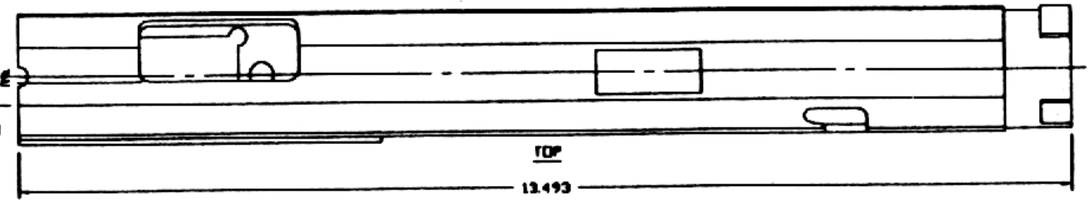


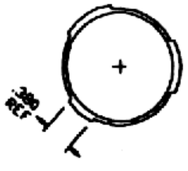


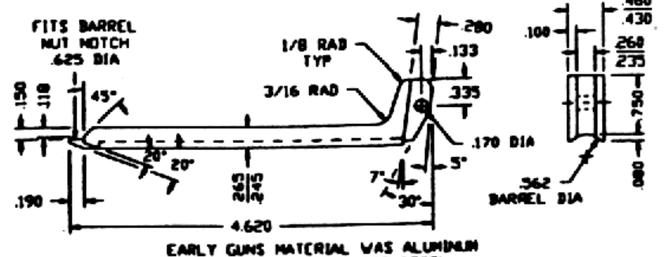
REAR SIGHT BASE

MATERIAL: 1020 STEEL









EARLY GUNS MATERIAL WAS ALUMINUM
FEW WERE STAMPED SHEET STEEL
LATE GUNS MATERIAL WAS BAKELITE OR SIMILAR

RESTING BAR

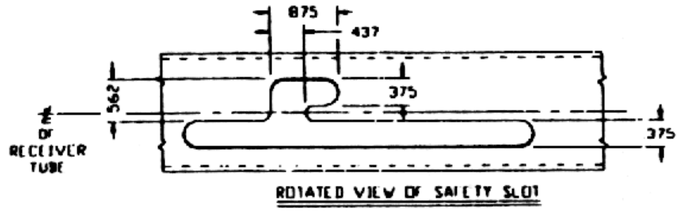
MATERIAL: 6061-T6 ALUMINUM

NOTES:
1. MATERIAL - 1 5/8 O.D. X 1 3/8 I.D. D.O.M. STEEL TUBE
2. FINISH - BLUE

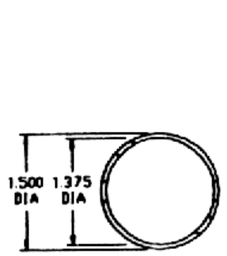
CONFIDENTIAL

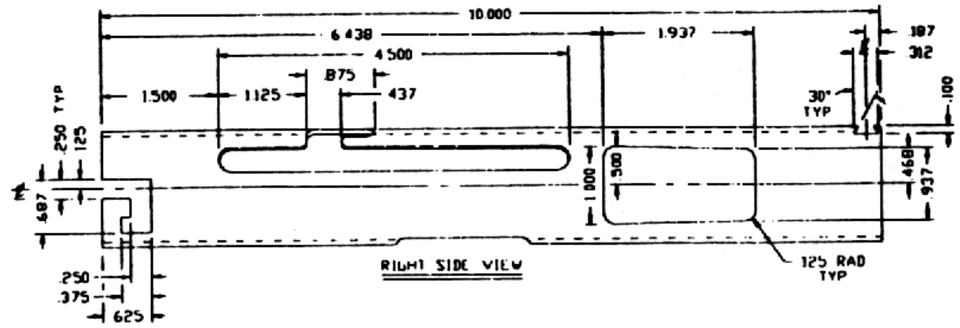
RESTRICTED MATERIAL

SCALE FULL	MATERIAL SEE NOTE 1	CAGE	TOLERANCES
DWN	FINISH SEE NOTE 2	DATE	
TITLE MP-40 RECEIVER		REV.	

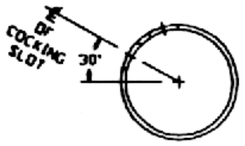


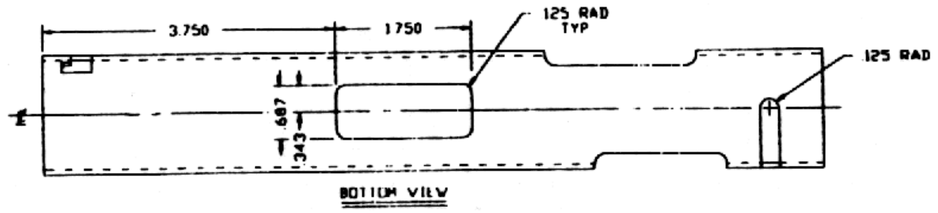
ROTATED VIEW OF SAFETY SLOT



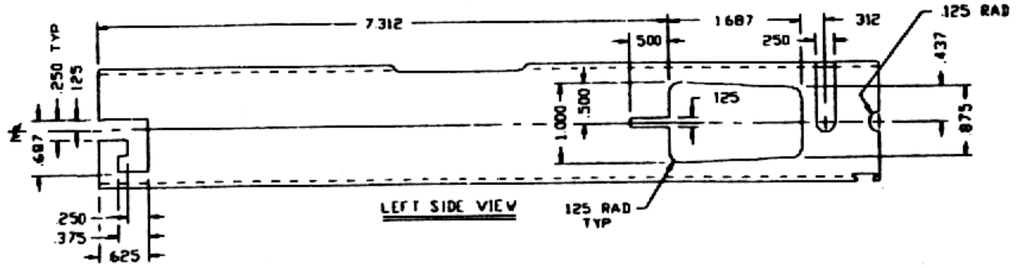


RIGHT SIDE VIEW

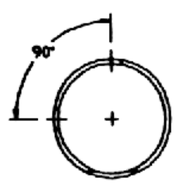




BOTTOM VIEW



LEFT SIDE VIEW



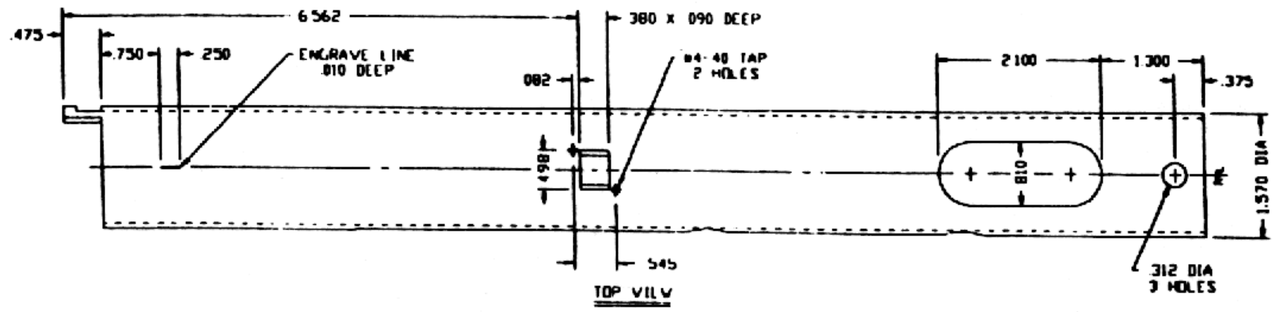
RESTRICTED MATERIAL

CONFIDENTIAL

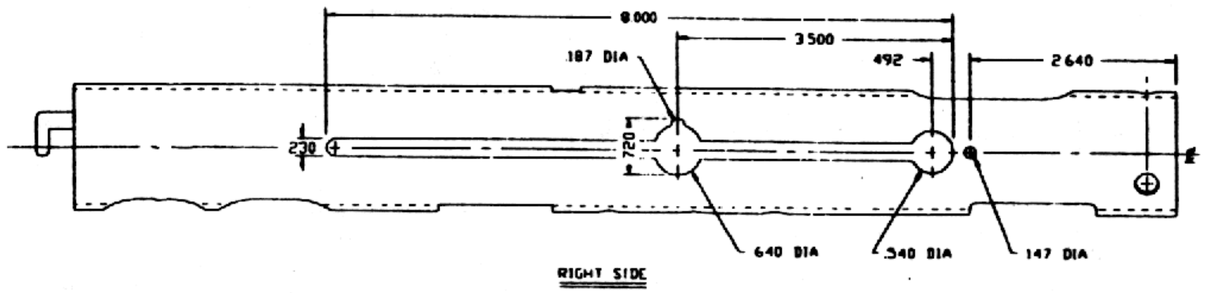
NOTES:

1. MATERIAL - MILD STEEL SEAMLESS , DRAWN OVER MANDREL 1.500 OD X 1.375 I.D. (.058-.062 WALL)
2. FINISH- PAINT BLACK

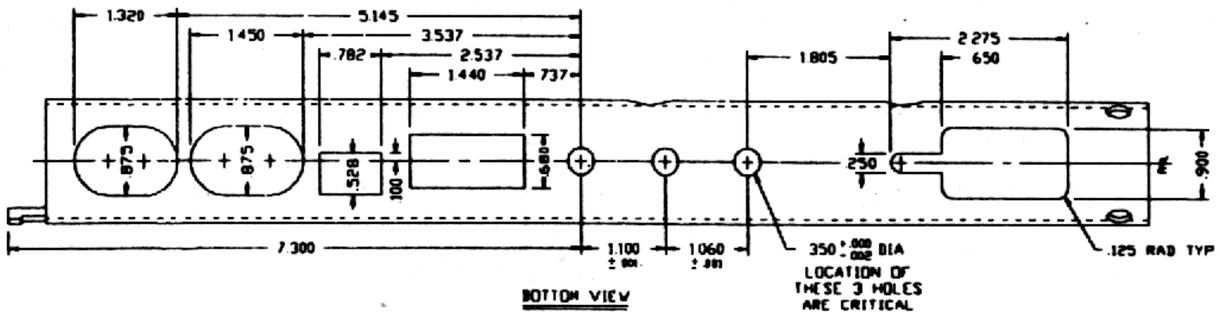
SCALE: FULL	MATERIAL: SEE NOTE 1	CRS	TOLERANCES
DWN	FINISH SEE NOTE 2	DATE	
TITLE: STEN MK-II RECEIVER (COMPACT MODEL)		REV.	ANGLES ± 0°



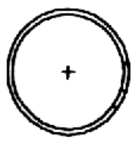
TOP VIEW

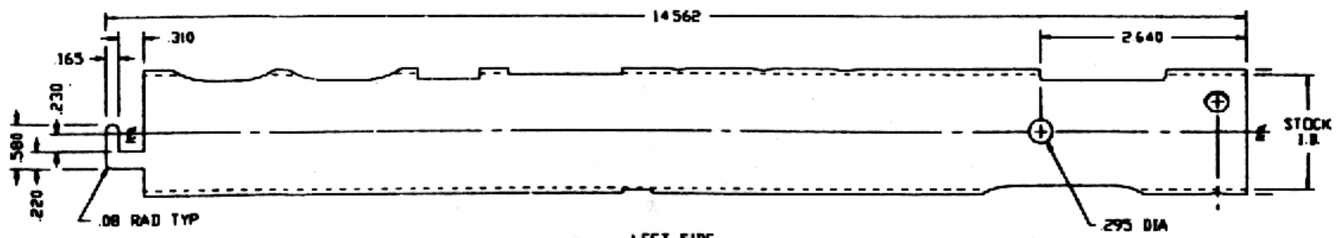


RIGHT SIDE

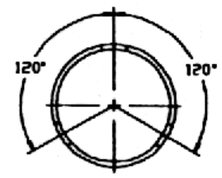


BOTTOM VIEW





LEFT SIDE



FRONT VIEW

METHOD OF ATTACHING BARREL BUSHING
DRILL .312 DIA HOLES AT 120° POSITIONED .375 FROM FRONT AND ELECTRIC WELD

ALTERNATE FOR NON-GUN COLD SOLDER OR SILVER SOLDER

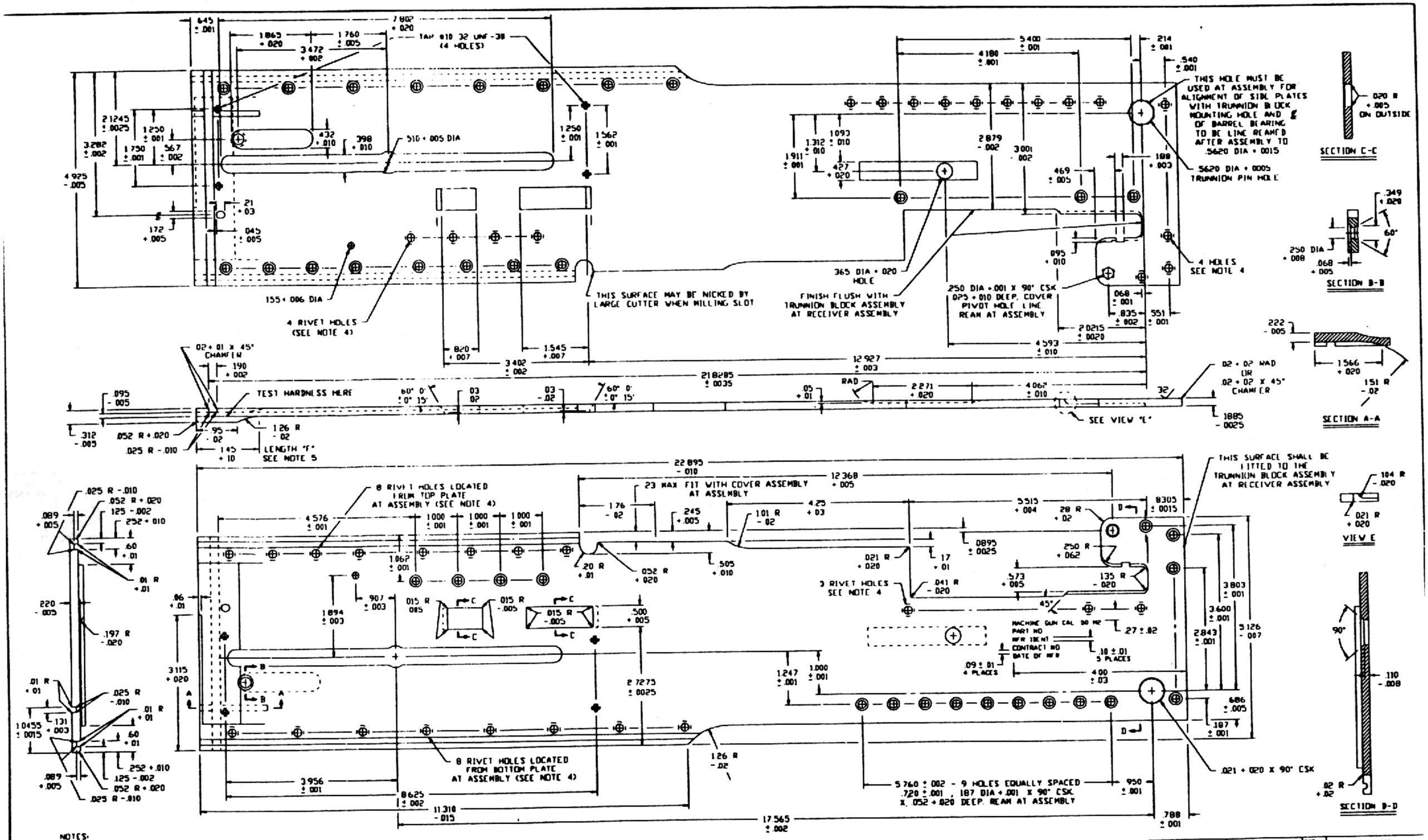
NOTES

1. MATERIAL- 1.625 O.D. x .093 WALL D.O.M. STEEL TUBE
2. FINISH- BLUE
3. CALIBER- 7.62 TOKAREV OR 7.63 MAUSER

RESTRICTED MATERIAL

CONFIDENTIAL

SCALE: FULL	MATERIAL: SEE NOTE 1	CHG.	TOLERANCES
DWN.	FINISH: SEE NOTE 2	DATE	
TITLE: YUGOSLAV 56 RECEIVER		REV.	ANGLES ± .5°
			NO.


TAP #10 32 UNF -3B (4 HOLES)
.510 + .005 DIA
155 + .006 DIA
4 RIVET HOLES (SEE NOTE 4)
THIS SURFACE MAY BE NICKED BY LARGE CUTTER WHEN MILLING SLOT
.365 DIA + .020 HOLE
FINISH FLUSH WITH TRUNNION BLOCK ASSEMBLY AT RECEIVER ASSEMBLY
THIS HOLE MUST BE USED AT ASSEMBLY FOR ALIGNMENT OF SIDE PLATES WITH TRUNNION BLOCK MOUNTING HOLE AND ℄ OF BARREL BEARING TO BE LINE REAMED AFTER ASSEMBLY TO .5620 DIA + .0015
.5620 DIA + .0005 TRUNNION PIN HOLE
4 HOLES SEE NOTE 4
.250 DIA +.001 X 90° CSK .025 + .010 DEEP, COVER PIVOT HOLE LINE REAM AT ASSEMBLY
SECTION C-C
SECTION B-B
SECTION A-A
.02 + .01 X 45° CHAMFER
TEST HARDNESS HERE
LENGTH "F" SEE NOTE 5
.02 + .02 RAD OR .02 + .02 X 45° CHAMFER
SEE VIEW "E"
8 RIVET HOLES LOCATED FROM TOP PLATE AT ASSEMBLY (SEE NOTE 4)
23 MAX FIT WITH COVER ASSEMBLY AT ASSEMBLY
THIS SURFACE SHALL BE FITTED TO THE TRUNNION BLOCK ASSEMBLY AT RECEIVER ASSEMBLY
VIEW E
3 RIVET HOLES SEE NOTE 4
MACHINE GUN CAL .50 M2
PART NO
MFR IDENT
CONTRACT NO
DATE OF MFR
8 RIVET HOLES LOCATED FROM BOTTOM PLATE AT ASSEMBLY (SEE NOTE 4)
.021 + .020 X 90° CSK
5.760 ± .002 - 9 HOLES EQUALLY SPACED .720 ± .001, .187 DIA + .001 X 90° CSK X .052 + .020 DEEP, REAM AT ASSEMBLY
SECTION D-D

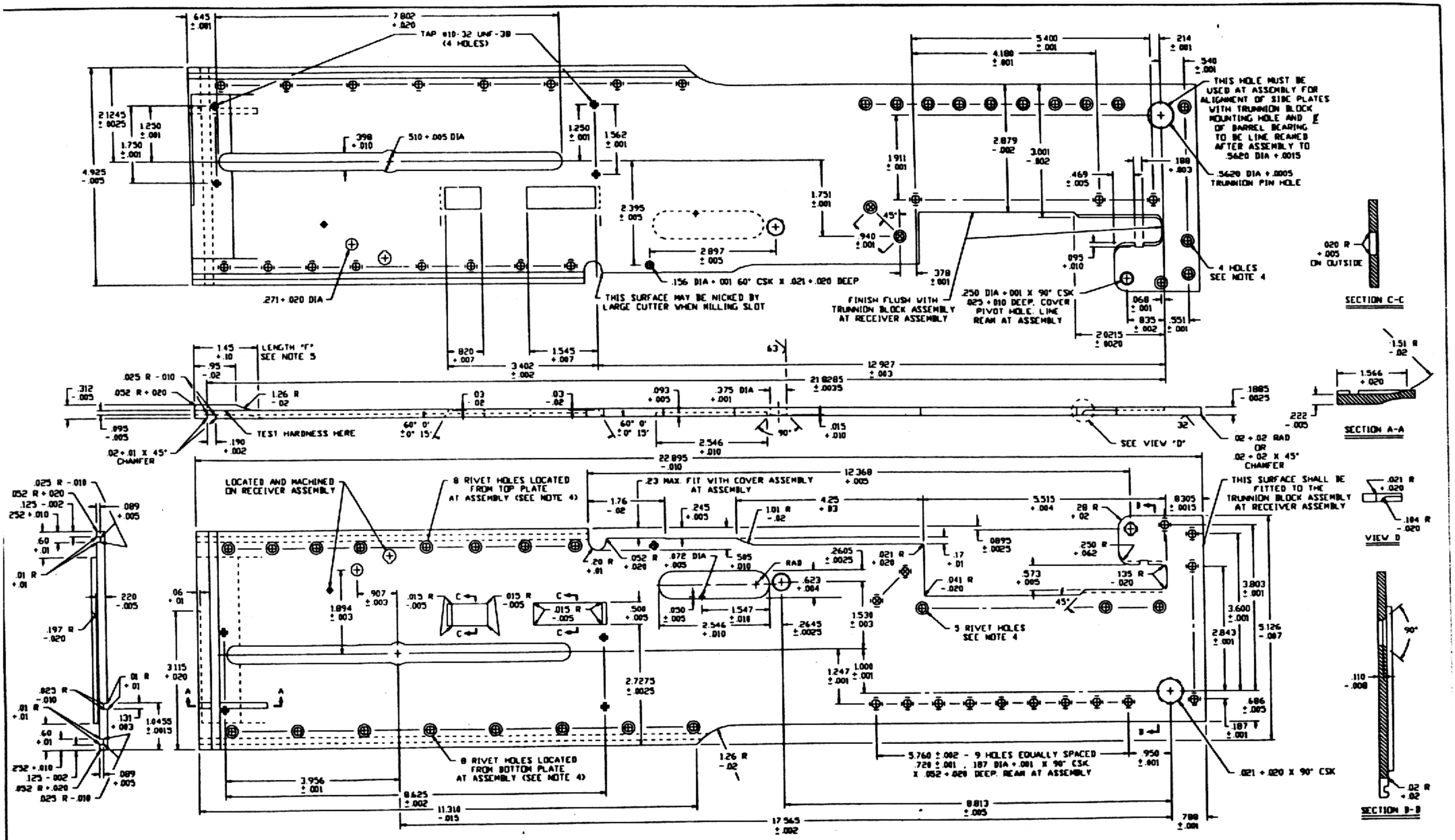
NOTES:

1. FINISH- 125 EXCEPT AS NOTED.
   MODEL 50 - POLICE MACHINE GUN BLUE
   MODEL 60 - SEMI-AUTO CIVILIAN BLUE
   MODEL 50 - MILITARY MACHINE GUN PARKERIZE
   MODEL 55 - PARATROOPER MACHINE GUN PARKERIZE
2. MATERIAL- STEEL, ASTM A331, 4340 OR 4130 OR 4140
3. BREAK EDGES .003 + .012 UNLESS OTHERVISE SPECIFIED.
4. ALL RIVET HOLES ARE .187 DIA + .001 (90° - 1° CSK .052 + .020 DEEP) REAM AT ASSEMBLY UNLESS OTHERVISE SPECIFIED.
5. HEAT TREATMENT- HEAT LENGTH "F" TO 1480° - 1500°F. OIL QUENCH. TEMPER AT APPROX 800° TO HARDNESS SPECIFIED.
6. MIL-W-13855 APPLIES

CONFIDENTIAL

RESTRICTED MATERIAL

SCALE: FULL	MATERIAL: SEE NOTE 2	CHG	TOLERANCES
DWN	FINISH: SEE NOTE 1	DATE	
TITLE: BMG50 RIGHT HAND SIDE PLATE		REV.	NO


TAP #10-32 UNF-3B (4 HOLES)
.510 +.005 DIA
.271 +.020 DIA
.156 DIA +.001 60° CSK x .021 +.020 DEEP
THIS SURFACE MAY BE NICKED BY LARGE CUTTER WHEN MILLING SLOT
FINISH FLUSH WITH TRUNNION BLOCK ASSEMBLY AT RECEIVER ASSEMBLY
.250 DIA +.001 X 90° CSK .025 +.010 DEEP. COVER PIVOT HOLE. LINE REAM AT ASSEMBLY
THIS HOLE MUST BE USED AT ASSEMBLY FOR ALIGNMENT OF SIDE PLATES WITH TRUNNION BLOCK MOUNTING HOLE AND OF BARREL BEARING TO BE LINE REAMED AFTER ASSEMBLY TO .5620 DIA +.0015
.5620 DIA +.0005 TRUNNION PIN HOLE
4 HOLES SEE NOTE 4
SECTION C-C
LENGTH "F" SEE NOTE 5
TEST HARDNESS HERE
.02 +.01 X 45° CHAMFER
SEE VIEW "D"
.02 +.02 RAD OR .02 +.02 X 45° CHAMFER
SECTION A-A
LOCATED AND MACHINED ON RECEIVER ASSEMBLY
8 RIVET HOLES LOCATED FROM TOP PLATE AT ASSEMBLY (SEE NOTE 4)
.23 MAX. FIT WITH COVER ASSEMBLY AT ASSEMBLY
THIS SURFACE SHALL BE FITTED TO THE TRUNNION BLOCK ASSEMBLY AT RECEIVER ASSEMBLY
5 RIVET HOLES SEE NOTE 4
8 RIVET HOLES LOCATED FROM BOTTOM PLATE AT ASSEMBLY (SEE NOTE 4)
5.760 ±.002 - 9 HOLES EQUALLY SPACED .720 ±.001 , .187 DIA +.001 X 90° CSK X .052 +.020 DEEP. REAM AT ASSEMBLY
.021 +.020 X 90° CSK
VIEW D
SECTION B-B

NOTES:

1. FINISH- 125 EXCEPT AS NOTED
   - MODEL 50 - POLICE MACHINE GUN BLUE
   - MODEL 60 - SEMI-AUTO CIVILIAN BLUE
   - MODEL 50 - MILITARY MACHINE GUN PARKERIZE
   - MODEL 55 - PARATROOPER MACHINE GUN PARKERIZE
2. MATERIAL - STEEL ASTM A331 4340 OR 4130 OR 4140.
3. BREAK EDGES .003 +.012 UNLESS OTHERWISE SPECIFIED.
4. ALL RIVET HOLES ARE .187 DIA +.001 (90° - 1° CSK .052 +.020 DEEP) REAM AT ASSEMBLY UNLESS OTHERWISE SPECIFIED.
5. HEAT TREATMENT- HEAT LENGTH "F" TO 1480° - 1500°F. OIL QUENCH. TEMPER AT APPROX 800° TO HARDNESS SPECIFIED.
6. MIL-W-13855 APPLIES
7. THE CLEARANCE CUT CONTROLLED BY DIMENSIONS 4.23 +.03 LENGTH, .17 +.01 DEPTH, AND 1.01 R -.02 IS OPTIONAL WITH MANUFACTURER TO MAKE THE LEFT AND RIGHT HAND SIDE PLATES ALIKE AS TO THIS CUT.

CONFIDENTIAL

SCALE FULL	MATERIAL SEE NOTE 2	CHG	TOLERANCES
DWN	FINISH SEE NOTE 1	DATE	
TITLE: BMG50 LEFT HAND SIDE PLATE		REV.	

SHEET 2 OF

RESTRICTED MATERIAL

LIST OF PARTS SUPPLIERS

wholesale guns and ammo, inc.
232 blydenburgh rd.
central islip, NY 11722

www.gunsnammo.com

international military antiques , inc.
p.o.box 256 millington ,NJ 07946

www.ima-usa.com

inter ordnance of america l.p.
3305 westwood industrial drive
monroe , NC 28110

www.inter-ordnance.com

sarco , inc.
323 union st. p.o. box 98
stirling , NJ 07980

jeffs shooters supply
p.o.box 1054 trussville , AL 35173

rpb industries
p.o.box 367 avondale est. GA 30002